

Replacement

1. Remove the related parts:

- Hood
- Front fender
- Front door
- Windshield
- Front side trim
- Door opening trim
- Kick panel
- Dashboard
- Front pillar trim
- Wire harness, etc.
- Steering column
- Steering hanger brace

NOTE: Make sure that the right and left pillars are parallel with the windshield surface. Check the door for proper opening and closing.

2. Pull out and straighten the damaged area.

- Pull out the damaged area with the frame straightener before cutting off the wheelhouse upper member and front pillar.

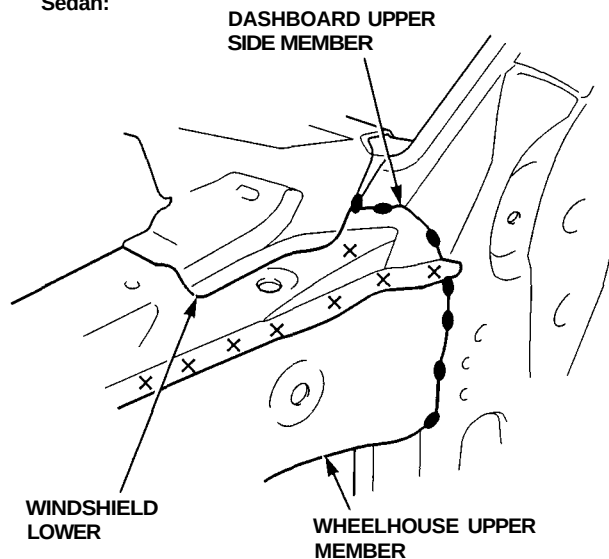
NOTE: Pull out until the pillar is lined up with the surface of the windshield.

- With the pillar pulled out, pull out and straighten the related lower dashboard and floor section.
- After pulling, check the inner pillar position using the body dimensional drawings (see [section 6](#)).

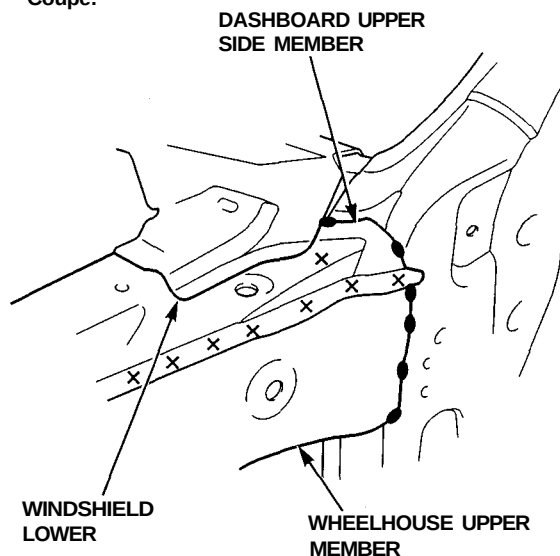
3. Remove the wheelhouse upper member.

Remove the spot welds and MIG welds of the windshield lower and dashboard upper side member, turn up them.

Sedan:



Coupe:



(cont'd)

Front Pillar (Outer Panel)

Replacement (cont'd)

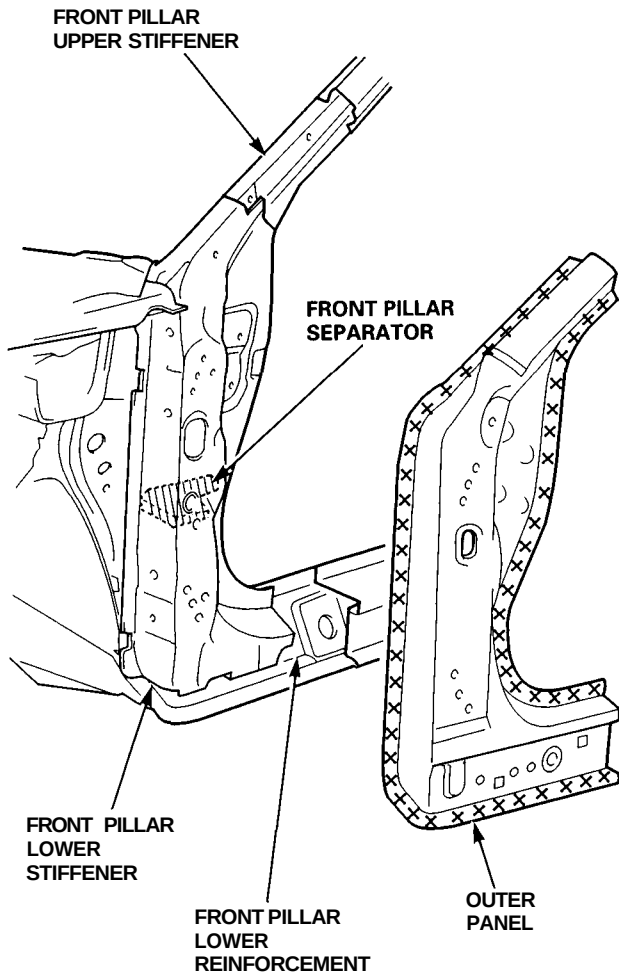
4. Cut off the front pillar.

- Use a die grinder to cut the windshield and side sill areas.

NOTE: Be careful not to cut the inner section.

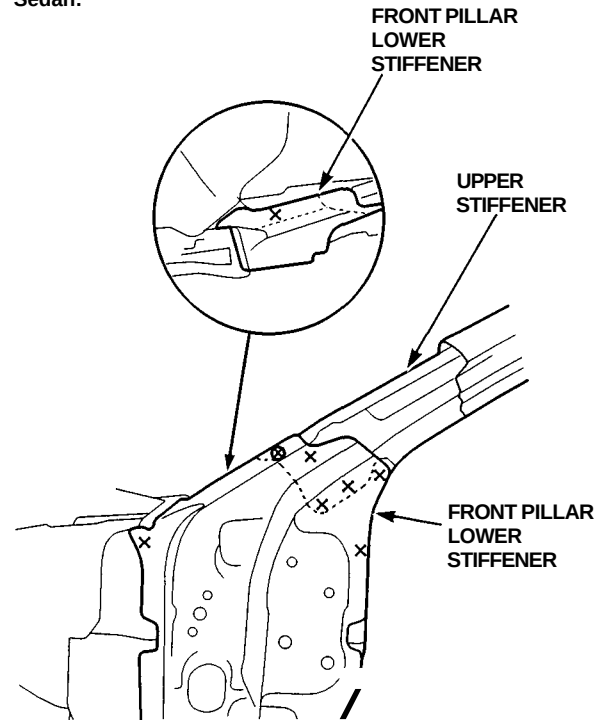
- Center punch around the spot weld imprints.
- Drill holes using a spot cutter.
- Chisel off the weld flanges.
- Finish the burrs at the drilled areas with a disc sander.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

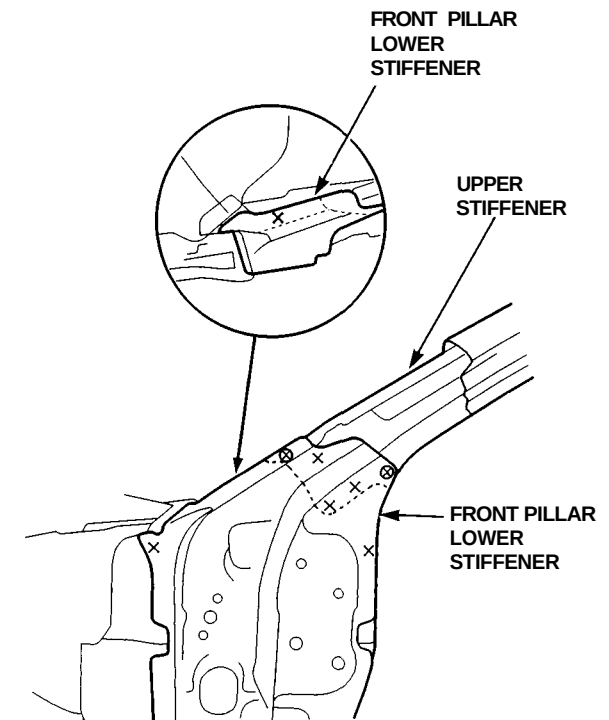


- Check the front pillar lower stiffener for position and damage, it necessary replace it.

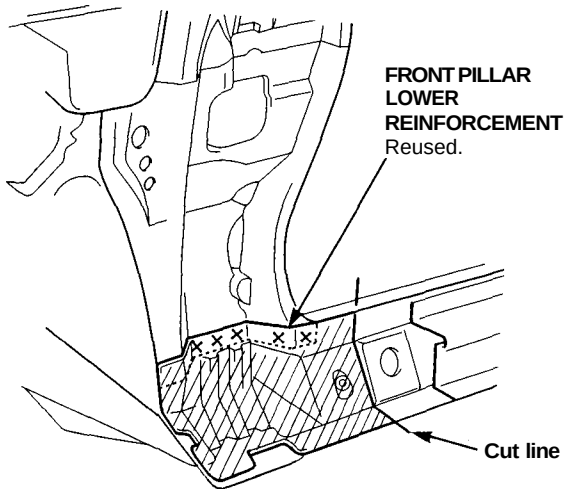
Sedan:



Coupe:



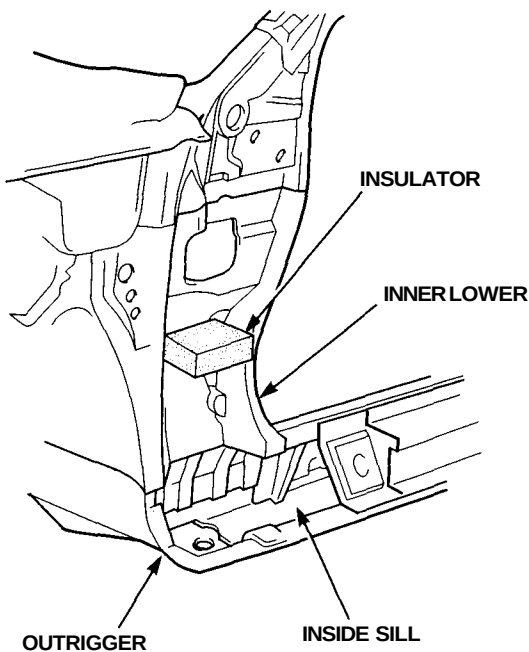
- Check the inner lower and inside sill for position and damage.
- Cut the front pillar lower reinforcement if necessary.



5. Straighten the related parts.

Fill any holes by MIG or gas welding and even out with a hammer and dolly.

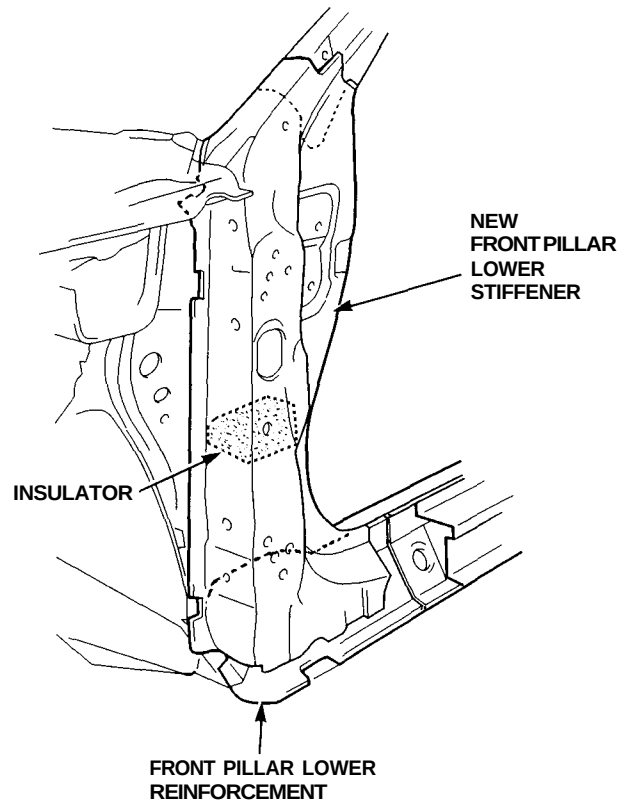
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.



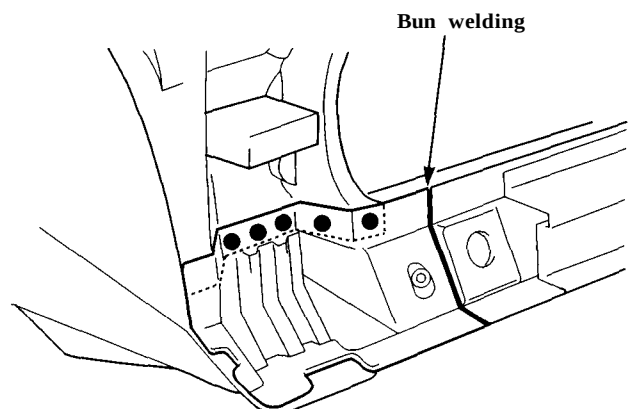
- Glue the insulator to the inner lower at the front pillar separator mounted position.
Insulator: P/N.74416-SF1-000
Adhesive: Cemedine 366 or equivalent

6. Set the front pillar lower reinforcement and new front pillar lower stiffener.

- Remove the undercoat from both sides of the areas to be spot welded with a sander to expose the steel plate.
- Check the position of the front pillar lower reinforcement and front pillar lower stiffener.



- Remove the new front pillar lower stiffener and weld the front pillar lower reinforcement.



(cont'd)

Front Pillar (Outer Panel)

Replacement (cont'd)

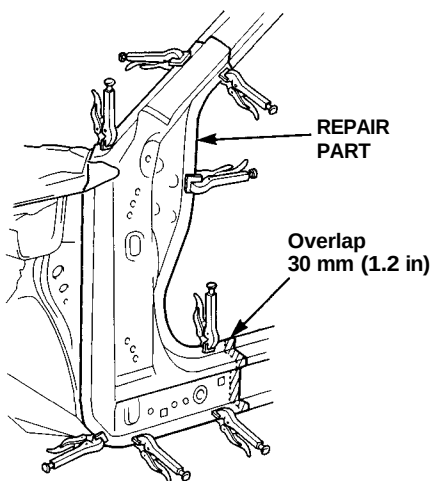
7. Set the new front pillar stiffener and repair part
 - Align the repair part with the top cut section, then cut it with a handsaw.

NOTE: Cut the side sill joint with a handsaw leaving an overlap of 30 mm (1.2 in).

- Remove the undercoat from both sides of the areas to be spot welded with a sander to expose the steel plate.

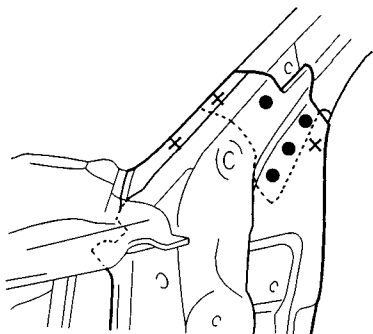
NOTE: Apply the spot sealer to the welding surface of the new front pillar stiffener.

- Clamp the new front pillar lower stiffener and the repair part.
- Check the body dimensions (see [section 6](#)).
- Temporarily install the door, and check the door hinge mounting position



8. Remove the repair part and weld the new front pillar lower stiffener.

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9. Apply spot sealer to the welding surface of the repair part.

10. Clamp the repair part and recheck the clearance and alignment of the door, front fender and windshield.

11. Perform the main welding.

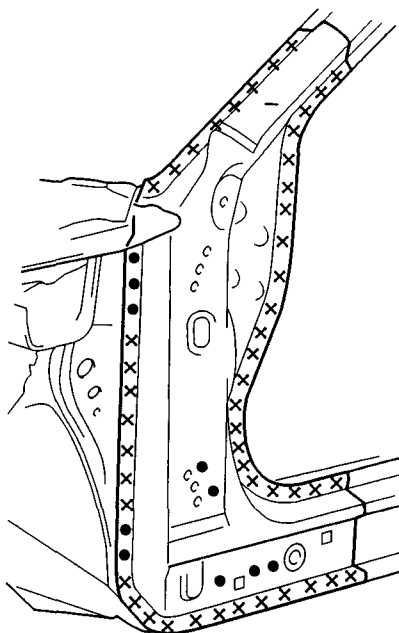
NOTE: Be careful not to burn the insulator of the fitting inside the front pillar lower stiffener while welding.

- Weld the front pillar and side sill outer joints with a MIG welder.
- Make 20% to 30% more spot welds than there were holes drilled.

NOTE: If there isn't room for spot welds, compensate by using MIG welds.

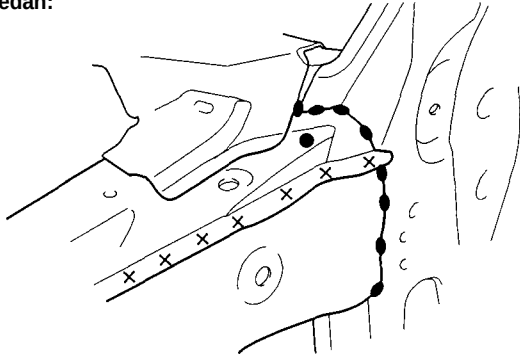
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Make 5 mm (0.2 in) holes in the MIG weld holes with the repair part, and weld the lower stiffener and dashboard upper side member with a MIG welder.

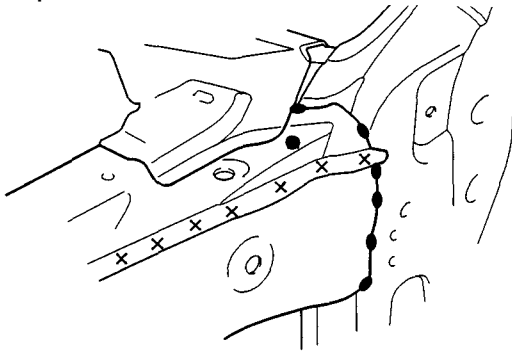


- Weld the dashboard upper side member, windshield lower and wheelhouse upper member.

Sedan:



Coupe:



12. Finish the welding areas.

- Grind the finishing allowance with a disc sander until it is smooth.

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- Smooth the flanged section of the door opening with a hammer and dolly.

13. Apply the sealer (see [section 5](#)).

14. Apply the paint.

See Paint Repair section.

⚠ WARNING

- **Ventilate when spraying paint.** Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
- **Avoid contact with skin.** Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- **Paint is flammable.** Store it in a safe place, and keep it away from sparks, flames or cigarettes.

15. Apply anti-rust agent to the inside of the front pillar, wheelhouse upper member, and side sill (see [section 7](#)).

16. Install the related parts.

- Install in the reverse order of removal.
- Check the door for proper installation and alignment with from the fenders.

17. Clean and check.

- After installing the dashboard, check the lights and gauges for proper operation.
- Clean the passenger compartment and check for water leaks.